

304 1.25

Work Order ID 80247

80247

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February-15-12 3:31:24 PM

Item ID: D3453-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Clevis

Start Date: 15/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 29/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: H.C.J.

Date: 12/02/16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3453	Rev B								

100

0.00

100

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA578
 Rev: N/A &
 Dwg D3453 Rev: 13
 2- Deburr as per dwg D3453

12/2/29

4 0

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

12/2/29

4 0

160

QC8- Inspect parts - second check

0.00

160

QC

Memo

0.00

Quality Control

B.A 12/03/01

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80247

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Item ID: D3453-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clevis
 Start Date: 15/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 29/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: WA	0.00							
170									
Packaging	Memo	0.00							
Packaging	*****STOCK IN LARGE FAB*****								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12-03-2
(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 80247

80247

Parent Item: D3453-3

D3453-3

Parent Item Name: Clevis

Start Date: 15/02/2012

Required Date: 29/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: A05.09.27New issueEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R1.250		Purchased	No			100	f	24.7400	0.2452	0.9808			
M304R1 250									**	SD 12/2/29			
304 round bar 1.250													

Location

Loc Qty

Loc Code

MAT029

24.74

105872

12.33

108156

1.68

111018

10.73

1 Lot

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	80247
Description: Clevis		Part Number:	D3453-3
Inspection Dwg: D3453 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø1.13	+0.012/-0.001	Ø 1.130	/		St-9	Uo/h
Ø0.755	+0.002/-0.005	Ø .756	/			
2.74	+/-0.030	2.738	/			
1.220	+/-0.010	1.218	/			
1.00	+/-0.030	1.00	/			
0.500	+0.010/-0.000	.508	/			
Ø0.375	+0.006/-0.001	Ø .380	/			
Ø0.129	+0.005/-0.001	Ø .129	/			
0.625	+/-0.010	.625	/			
0.450	+/-0.010	.450	/			

Measured by:	SA	Audited by:	BA	Prototype Approval:	N/A
Date:	12/2/29	Date:	12/03/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue	KJ/JLM	
B	09.11.04	Dimensions updated per Dwg Rev B	KJ	AM

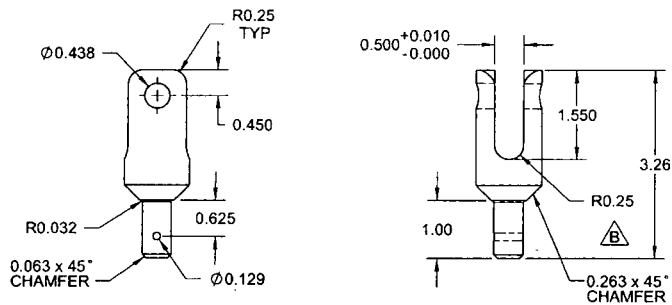
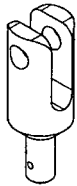
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

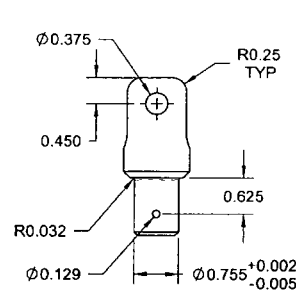
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3453-1 CLEVIS



D3453-3 CLEVIS

D3453-1/-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3453-1 = 0.41 lbs
D3453-3 = 0.41 lbs

UNCONTROLLED
SUBMITTAL
WORK CENTER
NO-80247 MLCJ
12/02/14

RELEASED
8/16/25 MFB

B	DRAWING UPDATED TO CURRENT STANDARDS; R0.25 WAS 0.050 (ZN CS-1, C2-1); 1.220 WAS 1.175 (ZN D1-1); REF PAR 09-018		RF	09.05.21
A	NEW ISSUE		RF	05.09.02
REV.		DESCRIPTION	BY	DATE
DESIGN		RF	<div>DART AEROSPACE LTD</div> <div>HAWKESBURY, ONTARIO, CANADA</div> <div>DRAWING NO. D3453</div> <div>TITLE CLEVIS</div> <div>COPYRIGHT © 2005 BY DART AEROSPACE LTD</div> <div>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</div>	
DRAWN		RF		
CHECKED		RF		
MFG. APPR.		RF		
APPROVED		RF		
DE APPR.		RF		
DATE		09.05.21		
		RF		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

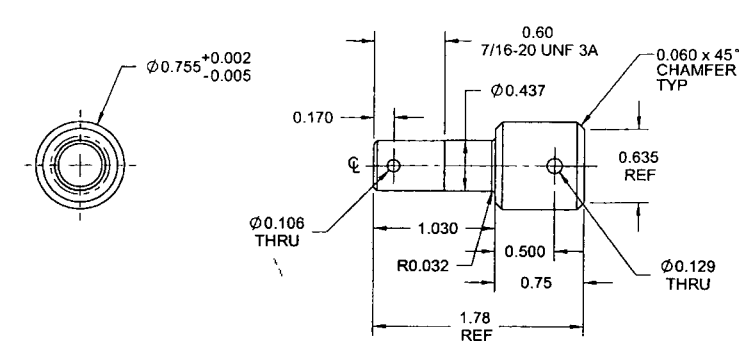
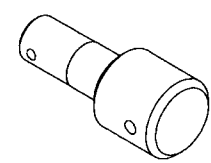
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

80247



D3453-5 PLUG

RELEASED
09/05/21

- D3453-5 NOTES:**
- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.13 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	<i>[Signature]</i>	DRAWING NO. D3453 REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE CLEVIS SCALE NTS
DE APPR.	<i>[Signature]</i>	
DATE	09.05.21	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries